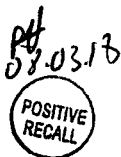


Date: Friday, 01/02/2008 9:28:54 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BASE	
Job Number : 37140		
Estimate Number : 13037		
P.O. Number :	Part Number : D365113	
This Issue : 01/02/2008 S.O. No. :	Drawing Number : D3651 REV.B U/R	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B U/R	
Previous Run : 35849	Material :	
Written By :	Due Date : 08/02/2008	Qty: 2 Um: Each
Checked & Approved By :		
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.7140 sf(s)/Unit Total : 1.4280 sf(s)
304/316 SS sheet 26 ga (0.018" thick)
Batch: 106996 B 8-2-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3651
Dwg Rev: B B 8-2-4
Prog Rev: B
2-Deburr if necessary B 8-2-4



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ENGINEERING APPROVAL
08.03.13 / 15.02.14

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and stock
Location: PPD 38103 / 10/3/18 @ 1808.03.12 @

Date: Friday, 01/02/2008 9:28:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 37140

Part Number: D365113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08 03 18
J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

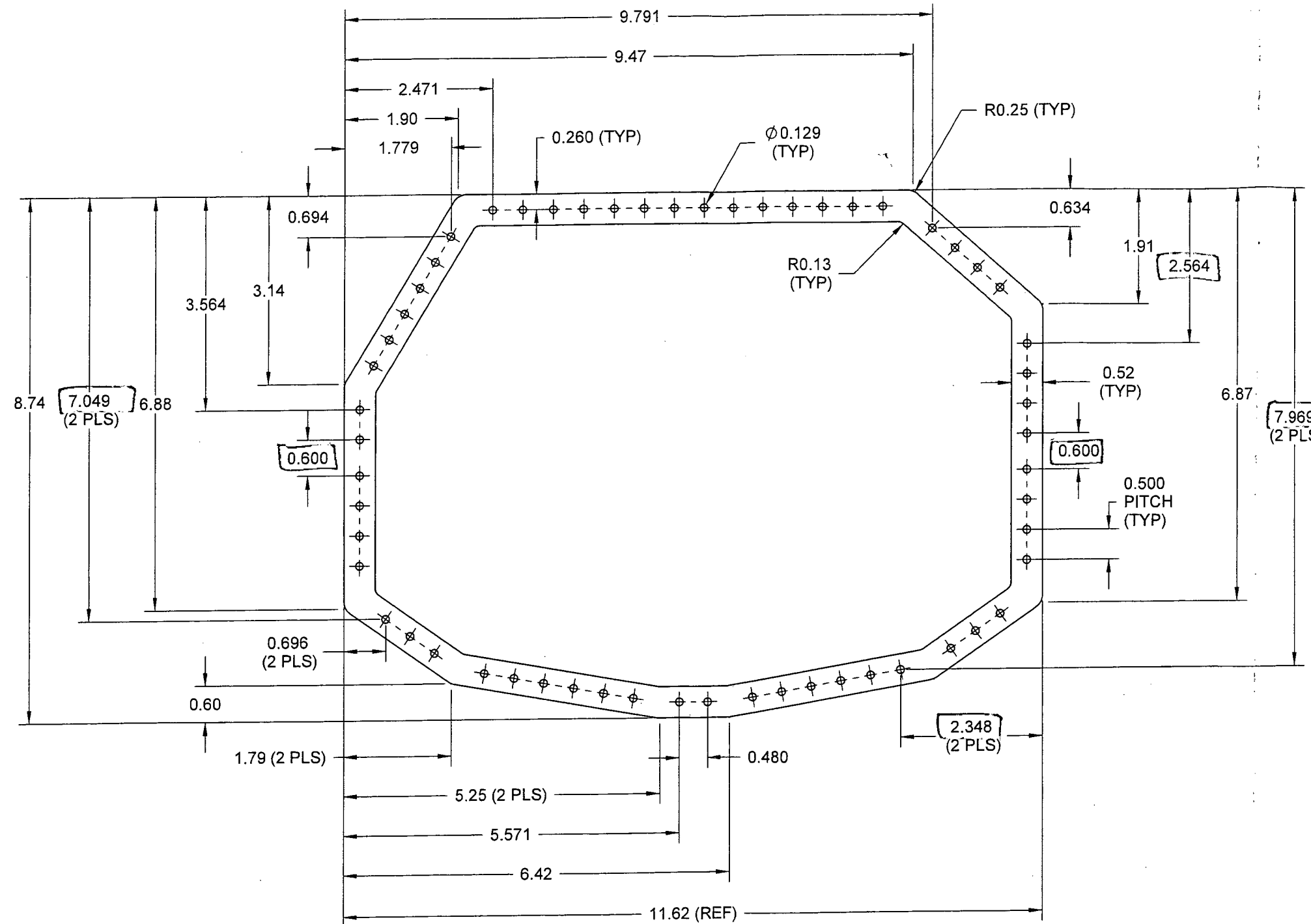


u 08-03-18

POSITIVE RECALL

EFFECTIVE 08-02-04 AUTH

RELEASED PH DATE 08-05-18



D3651-13 OUTSIDE DOUBLER B

PRELIMINARY ISSUE

LE 08.01.18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 9 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	37140
Description: AFT BASE		Part Number:	D 3651-13
Inspection Dwg: D3651-13 Rev: PREL		Page 1 of 1	

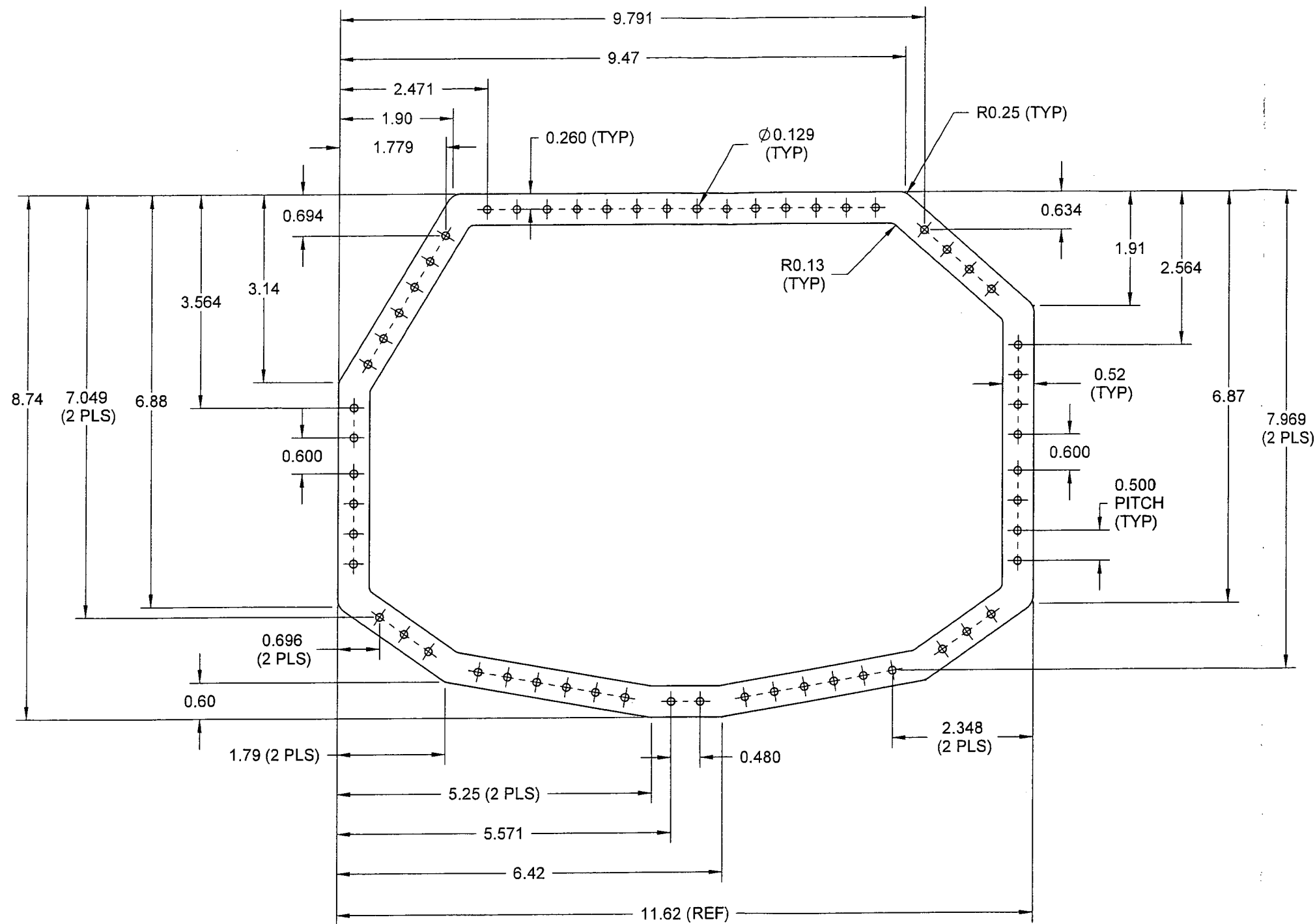
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.130	✓			
.260	± .010	.260	✓			
2.471	± .010	2.474	✓			
9.791	± .010	9.791	✓			
.634	± .010	.634	✓			
2.564	± .010	2.564	✓			
.52	± .030	.525	✓			
.600	± .010	.606	✓			
.500	± .010	.500	✓			
7.969	± .010	7.969	✓			
2.348	± .010	2.348	✓			
.480	± .010	.480	✓			
5.571	± .010	5.579	✓			
.696	± .010	.696	✓			
7.049	± .010	7.046	✓			
3.564	± .010	3.564	✓			
.694	± .010	.694	✓			
1.779	± .010	1.779	✓			
2.111	± .010					
8.74	± .030	8.74	✓			

Measured by: RB	Audited by: C	Prototype Approval: KE
Date: 8-2-4	Date: 08/02/04	Date: 08-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3651-13 OUTSIDE DOUBLER B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>ME</i>	DRAWING NO. D3651	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 9 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT BASE ASSEMBLY	1:2
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